



Date: Wednesday, 1/23/2008 12:06:22 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WELDMENT TOP PANEL
Job Number : 36942	
Estimate Number : 13029	
P.O. Number :	Part Number : D36503
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D3650 REV.B U/R
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B U/R
Previous Run : 35708	Material :
Written By : 	Due Date : 2/29/2008 Qty: 2 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC	
Est Rev:B ECN 1113P 08-01-22 DD	



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 1.2023 sf(s)/Unit Total : 2.4045 sf(s)
304/316 SS sheet 26 ga (0.018" thick)
Batch: 106996 IB 8-2-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3650
Dwg Rev: B IB 8-2-4
Prog Rev: B



2-Deburr if necessary IB 8-2-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Handwritten signature and circled number 2.

5.0	BRAKE NC	NC BRAKE
-----	----------	----------


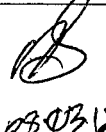
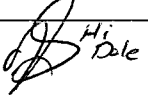

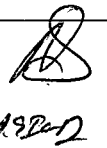


Comment: NC BRAKE
Form as per Dwg D3650

Handwritten signature and date 08-03-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 1D Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR: <u>36942</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5	080312	One scrap relais positioned in wrong place fabrication error		Scrap piece Qty (1)	 080312	 080312	 080312	 080312

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 12:06:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 36942

Part Number: D36503

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

060312
Parasso

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



① Trim to fit



Comment: Weld assembly as per dwg D3650

08-03-13 ①

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/03/13 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL
08-03-13

08/03/14 ②

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: *PPD 38103*

08/03/14 ②

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.03.18

Job Completion



08-03-14

POSITIVE RECALL

EFFECTIVE *08.01.31* AUTH *U*

RELEASED *14* DATE *08.03.18*

6.1 Pick

Δ 3650-11

Batch: 37911

08-03-13

08/03/13

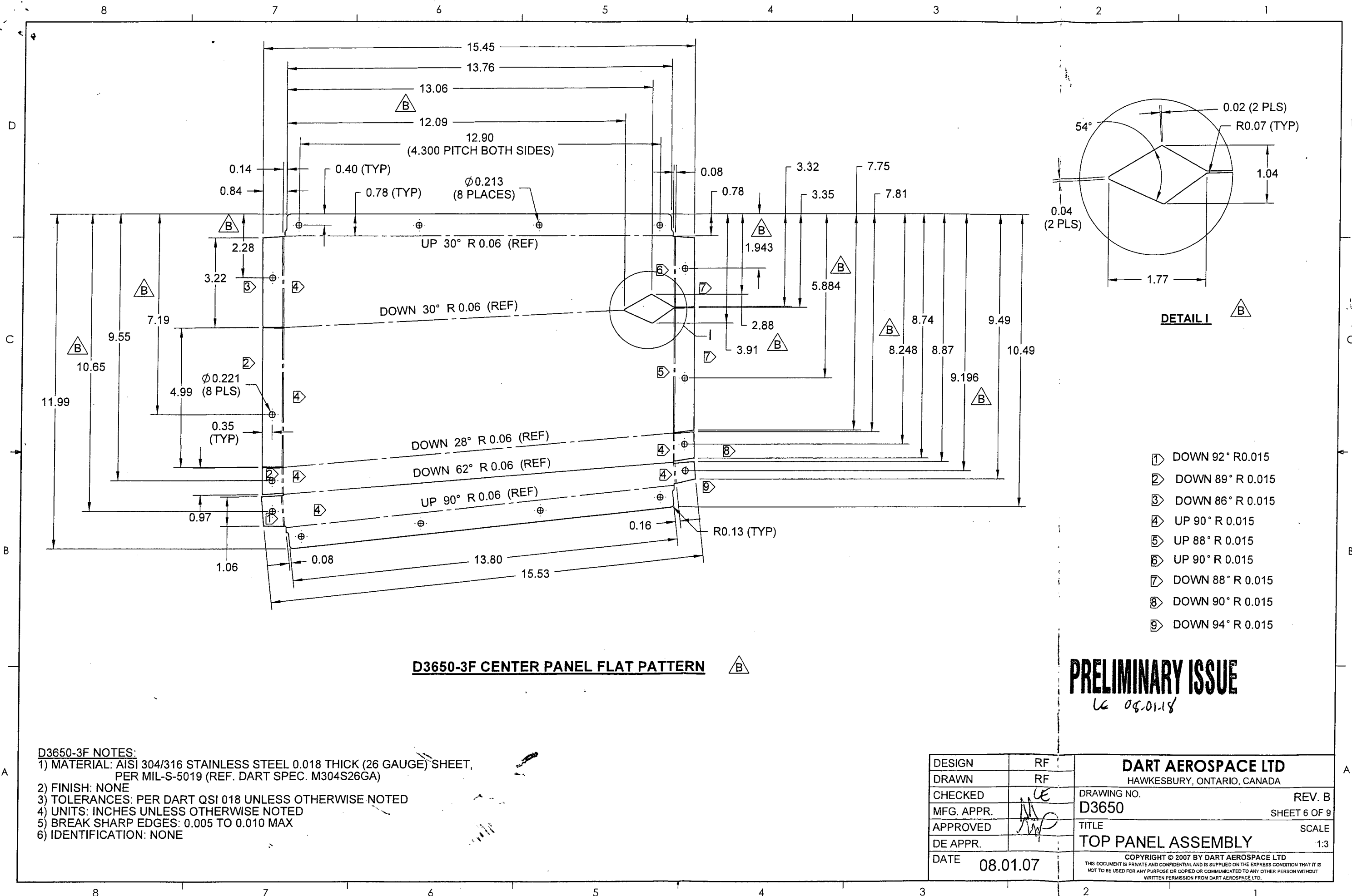
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

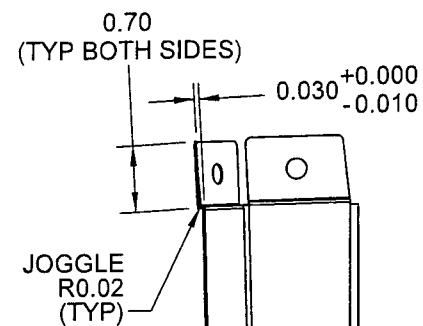


D3650-3F CENTER PANEL FLAT PATTERN

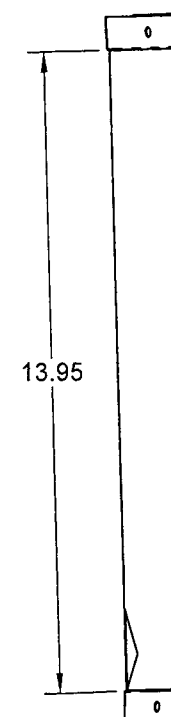
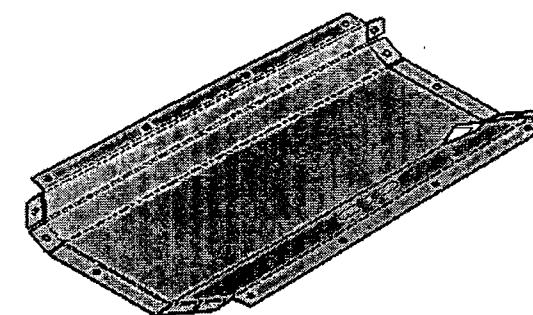
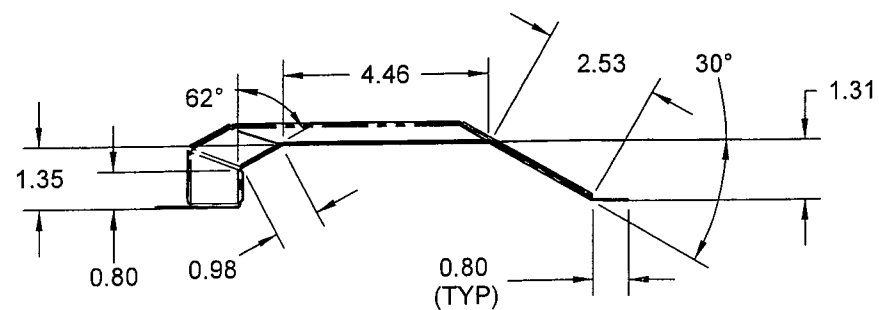
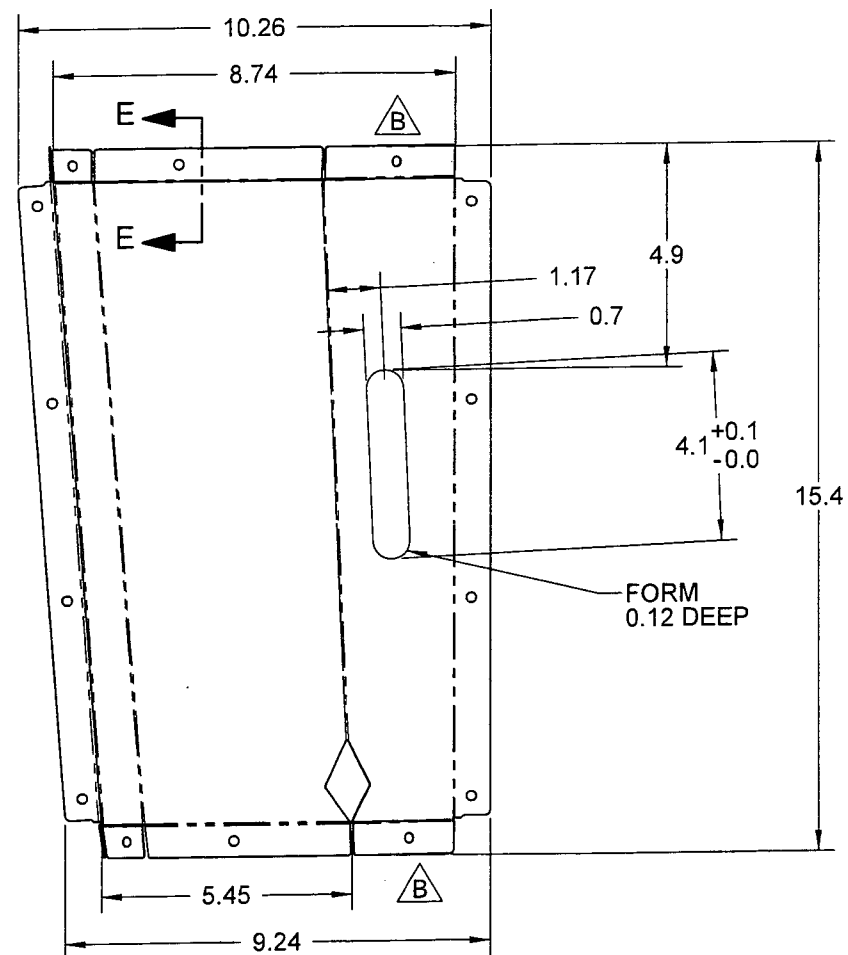
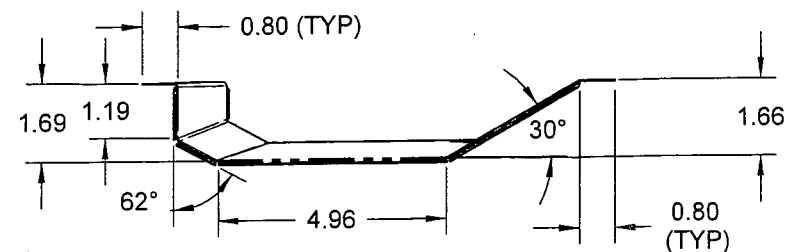
PRELIMINARY ISSUE
08.01.07

D3650-3F NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO. D3650	REV. B
MFG. APPR.	MP	SHEET 6 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION E-E

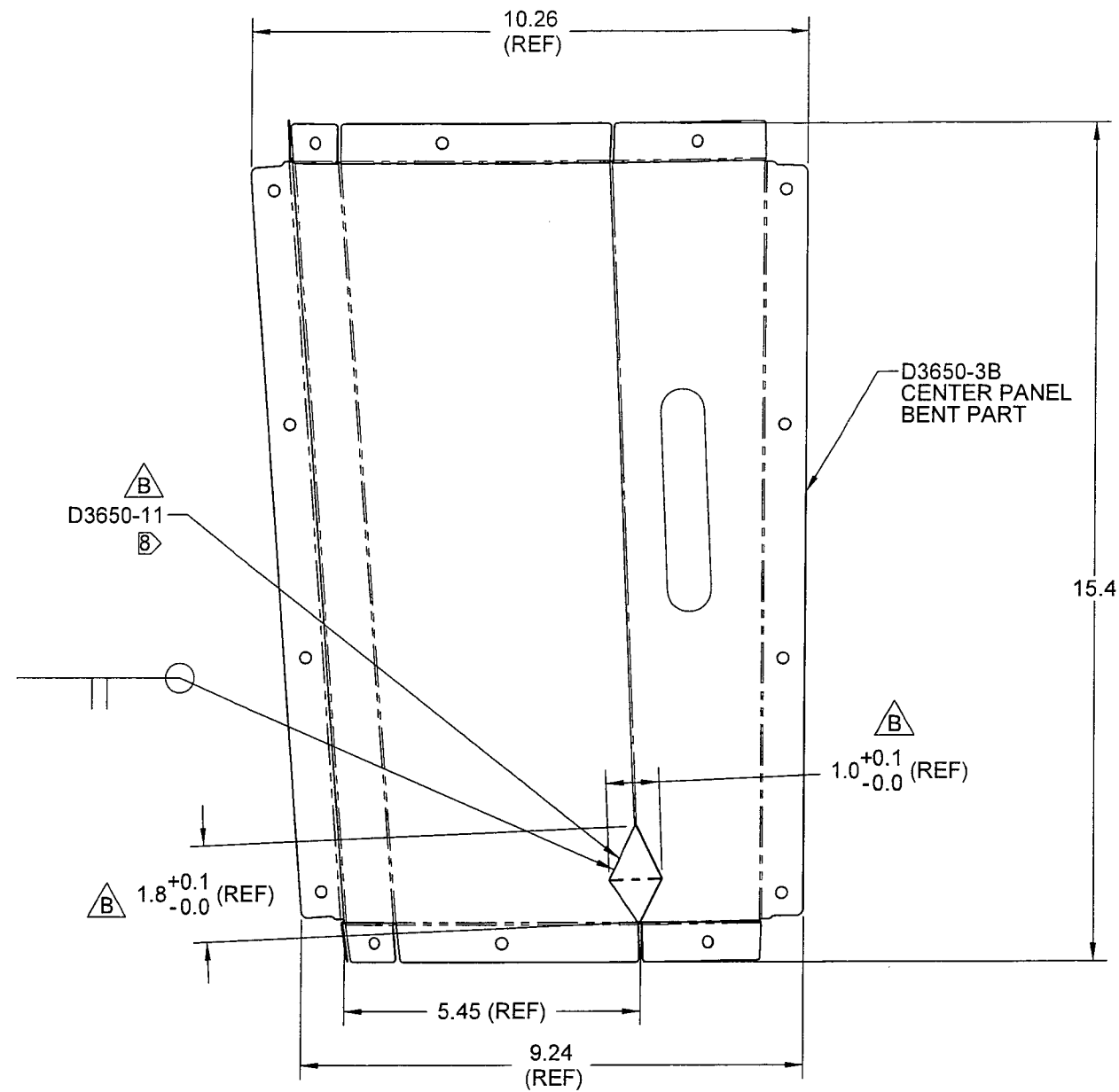


- NOTES:**
- 1) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE

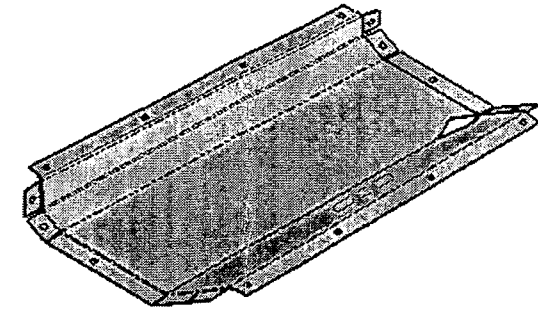
D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

PRELIMINARY ISSUE
08-01-18

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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D3650-3 CENTER PANEL



PART LIST

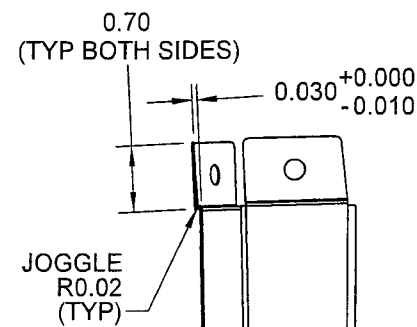
QTY	PART NUMBER	DESCRIPTION
-3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

NOTES:

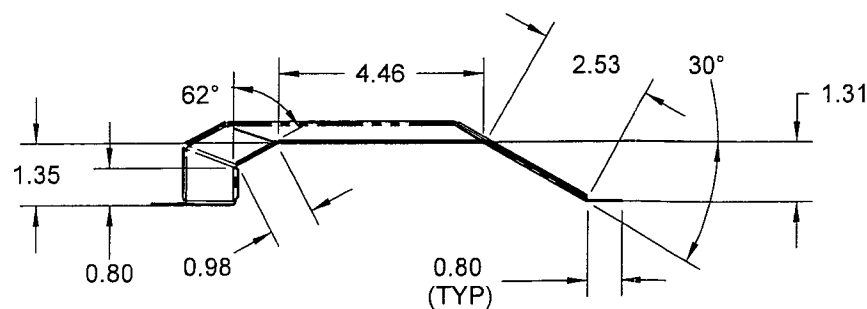
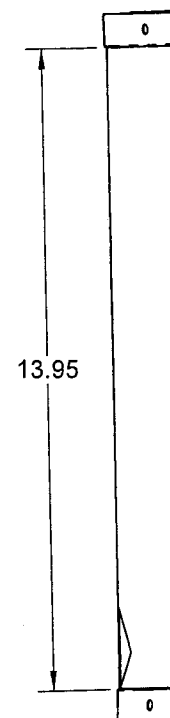
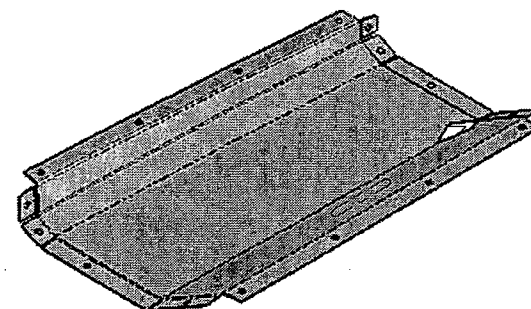
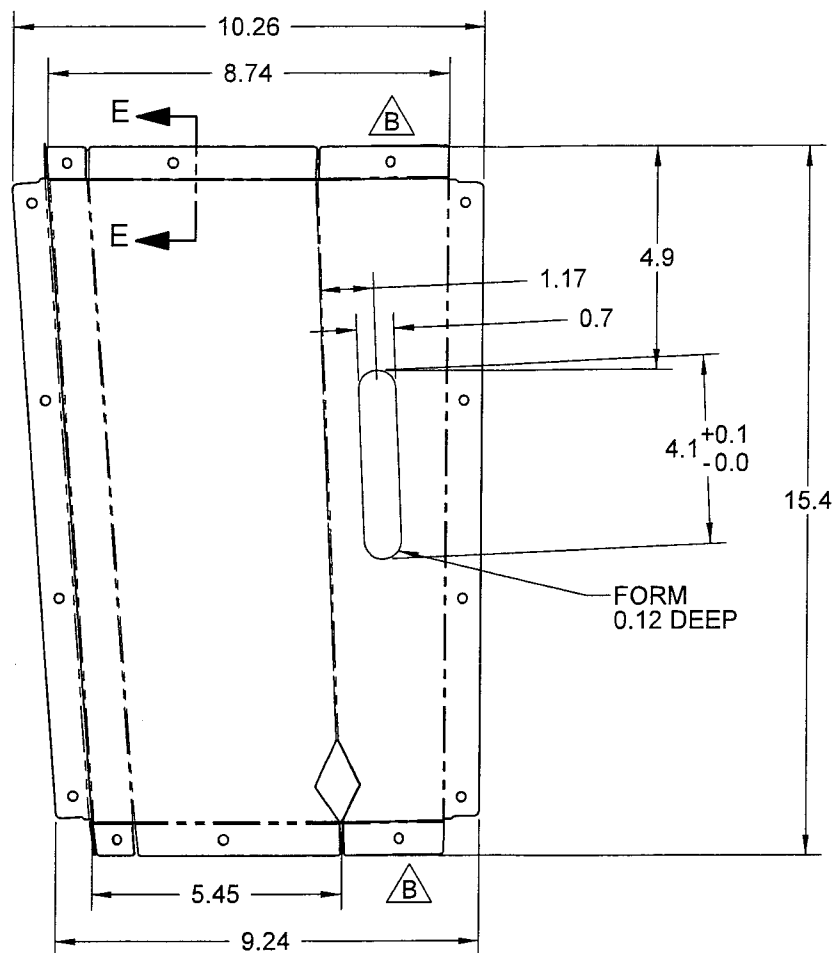
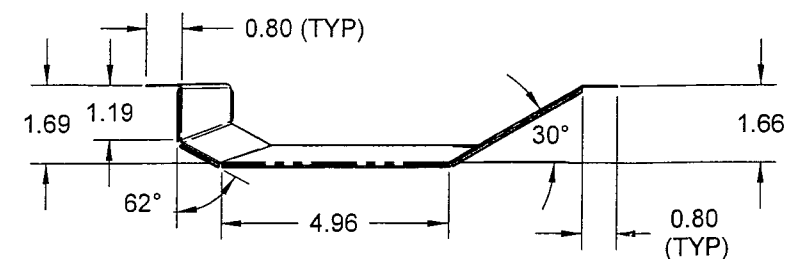
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3650	SHEET 4 OF 9
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	TOP PANEL ASSEMBLY	1:3
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SECTION E-E

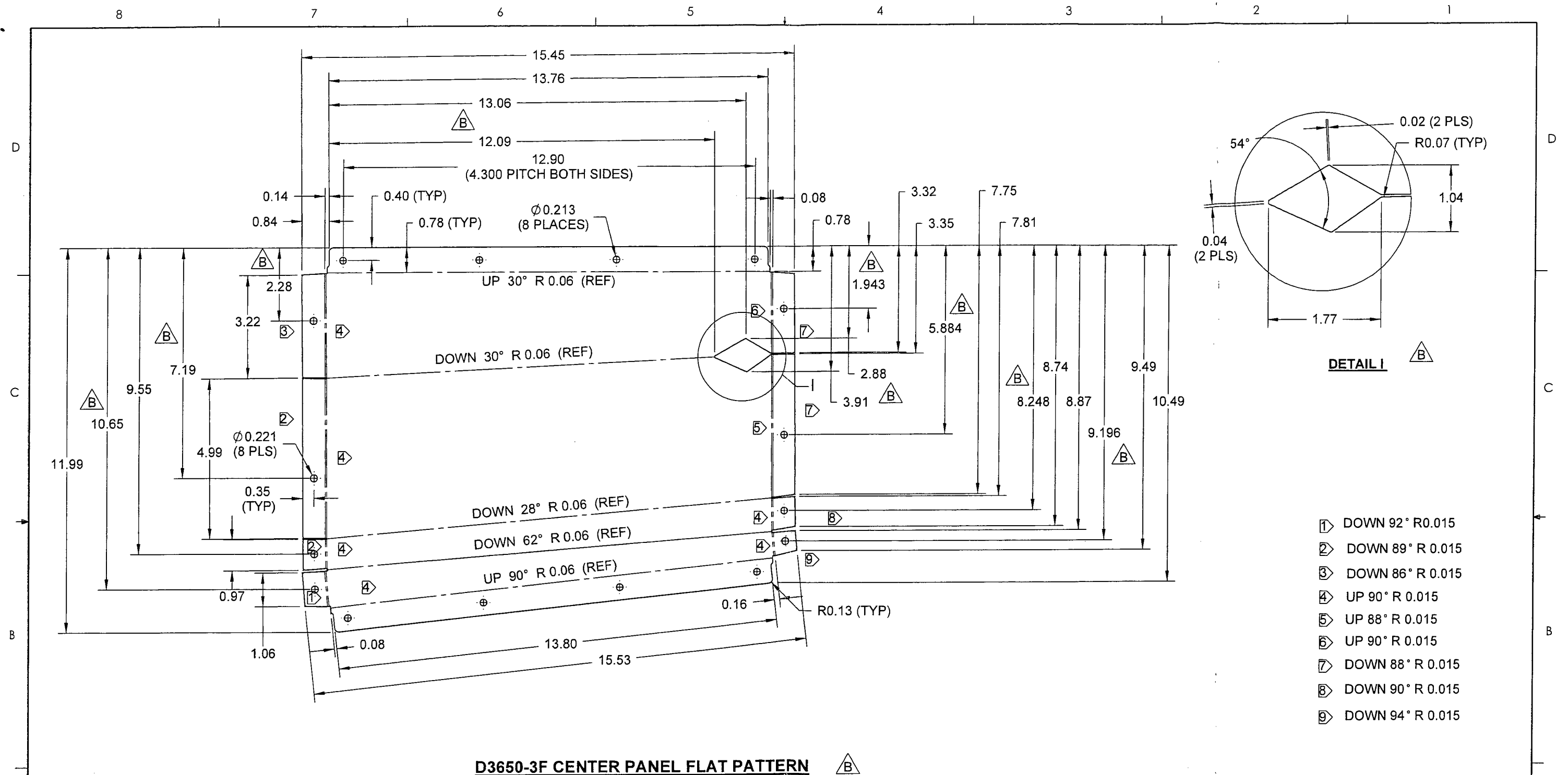


NOTES:

- 1) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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D3650-3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	MFG	D3650	SHEET 6 OF 9
APPROVED	APR	TITLE	SCALE
DE APPR.	DE	TOP PANEL ASSEMBLY	1:3
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